

Date: Tuesday, 6/12/2007 3:00:44 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG ASSEMBLY
Job Number : 32891	
Estimate Number : 10913	
P.O. Number : N/A	Part Number : D3405043
This Issue : 6/12/2007 S.O. No. : N/A	Drawing Number : D3405 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 27643	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 6/19/2007 Qty: 12 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est A 05.99.01 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S11GA	304/316 .125 Sheet
-----	-----------	--------------------



Comment: Qty.: 0.1617 sf(s)/Unit Total : 1.9404 sf(s)

304/316 .125 Sheet

(M304S11GA)

Batch: M102 817

SAD 07/06/15 12

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3405

Dwg Rev: A

Prog Rev: A

2-Debur if necessary

SAD

07/06/14 (12)

SAD

07/06/15

12

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD

07/06/15

12

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

En 07/06/14 (12)

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/06/14 (12)

(counted)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 6/12/2007 3:00:44 PM
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Process Sheet

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Drawing Name: LUG ASSEMBLY

Job Number: 32891

Part Number: D3405043

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr

Form using DT8204 as per Dwg D3405

* See Page #1 for QCS

SB

07/06/26

(12)

7.0

D34041

GHW Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

GHW Lug

Pick:

Qty Part number Description Batch

1 D3404-1 Lug

A/R SS Rod

B32897

M1014146

FC

07/07/08

(12)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D3405

Identify as D3405-043

FC

07/07/08

(12)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/07/09

(12)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/07/09

(12)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BR

07-07-13

(12)

12.0

QC3



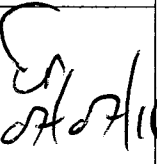
INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7/7/13

12x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/16/27	#5.0	Change step #5.0 (QC#5) to After Bending step #6.0		 07-07-16		 07-07-16	 07-07-16

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: EL Date: 07/16/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 6/12/2007 3:00:44 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 32891

Part Number: D3405043

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1

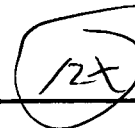


Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/7/16 SP



14.0

QC21

FINAL INSPECTION/W/O RELEASE



07.07.16

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 07.07.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

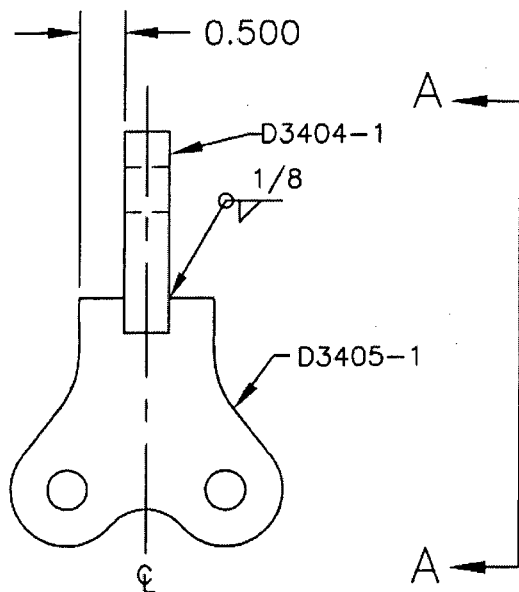
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

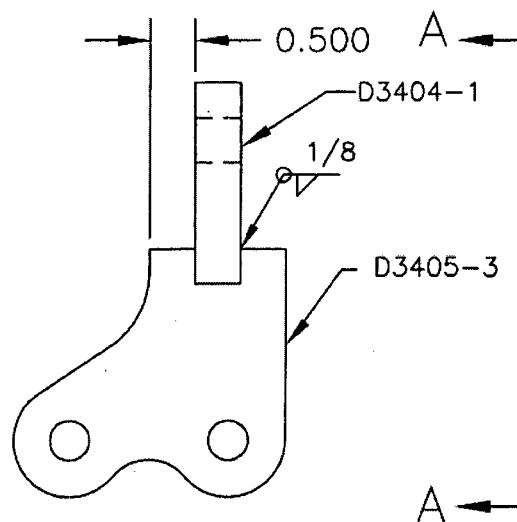
NOTE: Date & initial all entries



DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3405	REV. A SHEET 1 OF 2
DATE 05.03.08		TITLE GHW LUG ASSEMBLY	SCALE 1:2
A	05.03.08	NEW ISSUE	



D3405-041 LUG ASSEMBLY



D3405-043 LUG ASSEMBLY

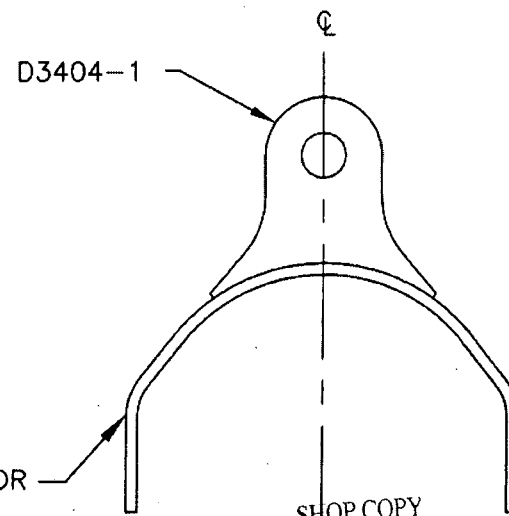
PARTS LIST FOR D3405-041/-043 LUG ASSEMBLY

QTY - 041	QTY - 043	PART NUMBER	DESCRIPTION
X		D3405-041	LUG ASSEMBLY
	X	D3405-043	LUG ASSEMBLY
1	1	D3404-1	GHW LUG
1		D3405-1	GHW BRACKET
	1	D3405-3	GHW BRACKET

RELEASED
05-08-09

D3405-041/-043 LUG ASSEMBLY

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT ASSEMBLY WHITE PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRIC ABOUT CENTERLINES



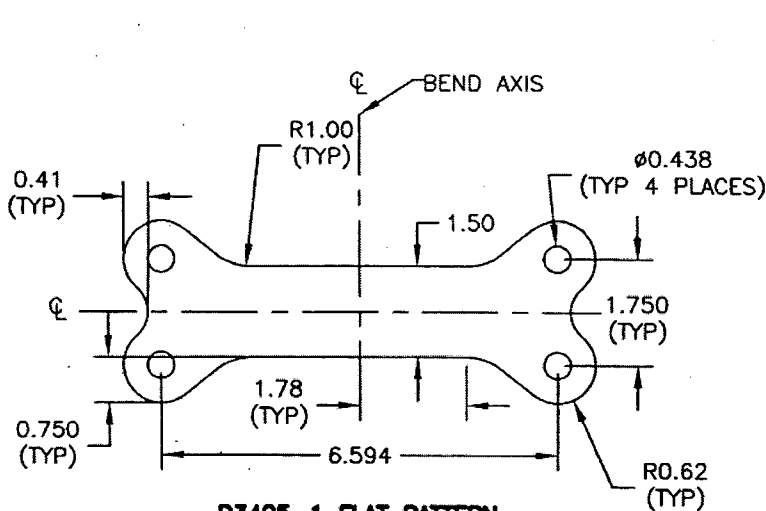
SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32891

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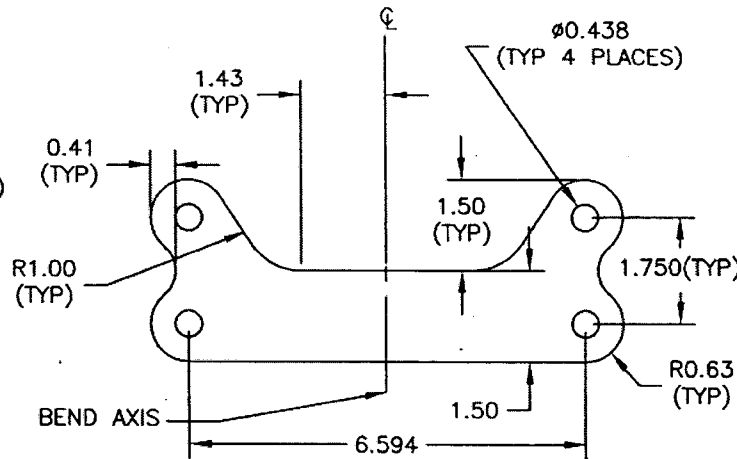
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DART

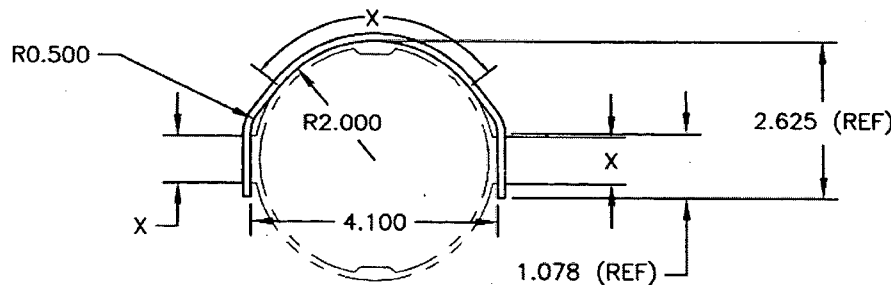
DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	05.03.08	DRAWING NO.	D3405	REV. A
		TITLE	GHW LUG ASSEMBLY	SHEET 2 OF 2
				SCALE 1:3



D3405-1 FLAT PATTERN
(SYMMETRIC ABOUT CENTERLINES)



D3405-3 FLAT PATTERN
(SYMMETRIC ABOUT CENTERLINES)



D3405-1 AND D3405-3 BEND DETAIL
D3405-1 AND D3405-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

D3405-1/-3 GHW BRACKET

- 1) MATERIAL: AISI 304/316 SS SHEET 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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05-08-04
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NO. 32891
WORK ORDER

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